

Work Order ID 104409

July-09-13 12:55:47 PM

104409

Page 1

Item ID: D4085-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: PLACARD

Stop

NS2

Start Date: 7/04/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/09/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 13-07-10

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 20522								
	E-mail or Ship electronic file and or dwg to vendor								
	Manufacture as per Dwg and supplied files								
	Possible supplier: Studio Letrage								
	Material release note is required.								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging									

CL1316710 (10)

143/18 (10)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
Bending	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced Set-up <input type="checkbox"/>
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
Cuffs	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	
Crushing	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	
Heat Treat	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>		
Marks/Chatter	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>		
Turning Sequence	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>		
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>		

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Work Order ID 104409

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104409

Page 2

Item ID: D4085-3

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: PLACARD

Stop

NS2

Start Date: 7/04/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/09/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00	DAS 27 13-7-18			10			

130 *130* Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00 0.00	STOB 13-7-18		OK	SD	13-7-18.
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140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00		MJS	13-7-22		MB 07-19
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
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Material									
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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Folio/Program	Outside Dimensions
Bending	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>
Cuffs	Contamination <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>
Crushing	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>
Heat Treat	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Pressure/Forced Set-up <input type="checkbox"/>
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Off-set <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
Marks/Chatter	Drill Holes <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>	Weld <input type="checkbox"/>
Turning Sequence	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>		Other <input type="checkbox"/>

Picklist Print

July-09-13 12:55:47 PM

Page 1

Work Order ID: 104409

Parent Item: D4085-3

Parent Item Name: PLACARD

Start Date: 7/04/13

Required Date: 7/09/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.08.18 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4085-3P Placard, Instructions		Purchased	No		110		Each	0.0000	1	10		7/3/18 (10)	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

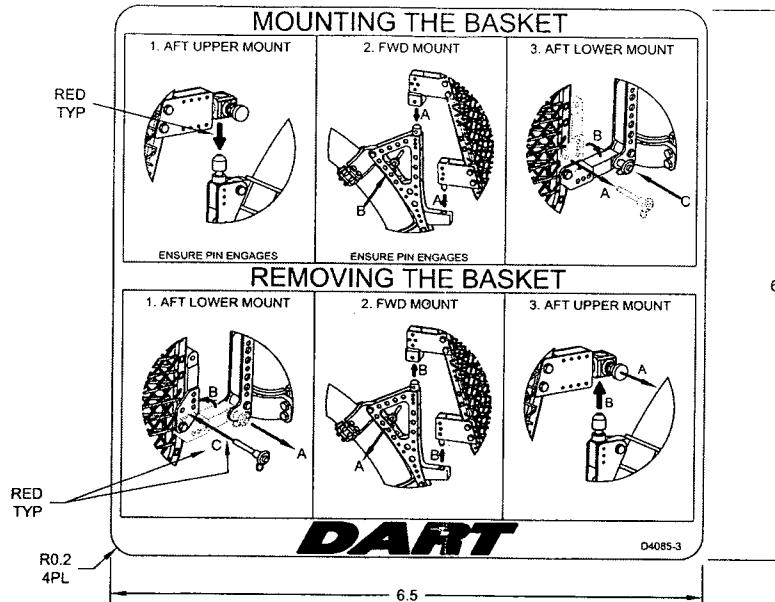
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

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Centre Not Concentric	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>
Cuffs	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
Crushing	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	
Heat Treat	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>		
Marks/Chatter	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>		
Turning Sequence	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>		
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>		

D

D



D4085-3 PLACARD, INSTRUCTIONS

RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: BLACK LETTERS AND GRAPHICS WITH RED ARROWS AND LOGO ON WHITE BACKGROUND AND ADHESIVE BACK.
MANUFACTURED FROM 3M, 7 MIL MASKING FILM #8522CP OR
AVERY IPM #2031
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) USE FILE D4085-3C.eps FOR GRAPHICS

8 7 6 5 4 3 2 1

DESIGN	IPH	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.	N/A	REV. C
APPROVED		D4085
DE APPR.		SHEET 2 OF 2
DATE	10.06.25	TITLE
		PLACARD, INSTRUCTIONS
		SCALE
		NTS

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO20522**

Purchase Order Date 7/11/2013

PO Print Date 7/11/2013

Page Number 1 of 1

Order From :
STUDIO DE LETTRAGE 2001
210 MAIN WEST
HAWKESBURY, ON K6A 2H6
CA

VC-STU001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
(07/13/2013)

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 632 5449	Customer POID	
Ship To Contact		Customer Tax #	10127-2607
Ship To Phone		Terms	Net 30
Ship Via:	Yours ppd	Currency	CAD
Ship Acct:		FOB	Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	List Price	Disc %	Discounted Unit Price	Extended Price
1	D2269P	Placard	7/17/2013	Yes	10.00 Each				\$75.00
	AS PER DWG D2269 REV. B B104393		7/17/2013						

Line Total: \$75.00

2	D4085-3P	Placard, Instructions	7/17/2013	Yes	10.00 Each				\$75.00
	AS PER DWG D4085 REV. C B104409		7/17/2013						

Line Total: \$75.00

PO Total: \$150.00

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required - YES NO

Change Nbr:

1

Change Date: 7/11/2013

Studio de Lettrage

210 Main Street W
Hawkesbury, Ontario K6A 2H6

INVOICE

Invoice No.: 20521
Date: 07/17/2013
Ship Date:
Page: 1
Re: Order No. WO10406

Sold to:

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario K6A 1K7

Ship to:

Dart Aerospace Ltd
Hawkesbury, Ontario

Business No.: 82500 7651 RT0001

Item No.	Unit	Quantity	Description	Tax	Unit Price	Amount
			10 AVERY STICKERS D2269P 1 SET UP 10 AVERY STICKERS D4085-3P 1 SET UP PO#20522	H	2.50 50.00 6.00 50.00	25.00 50.00 60.00 50.00
H - HST 13% HST						24.05
Studio de Lettrage HST: #825007651RT0001						
Shipped By: Tracking Number:						
Comment:						Total Amount
Sold By:						209.05

****Certificate of Conformity****

Customer:

Studio hettlage

Purchase Order #:

20522

Packing Slip #:

10466

Part #:

Serial #:

Description:

D2269P & D4085-3P

Quantity:

10 each

Certification:

We hereby certify that:

1. The above the listed items were manufactured, repaired and/or inspected in accordance with applicable drawings and/or specifications;
2. All work was accomplished in accordance with the Dart Aerospace Purchase Order;
3. Results of all inspections, chemical or physical tests, as well as other evidence, which shows the acceptability of raw materials, parts and/or assembly components are on file and available for inspection at any time.

Authority:

Avery

APPROVAL:

Project Coordinator

DATE:

Signature:

Karen St. Marie

Title:

Karen St. Marie

July 17, 2013.

PRODUCT DATA SHEET



Avery® IPM™ 2031

issued: 01/04/2005

Introduction

Avery® IPM™ 2031 is a high quality pressure-sensitive vinyl film, designed for use on wide format inkjet printers. Avery® IPM™ 2031 has excellent printing properties, allowing crisp print quality with bright and vibrant colours. Avery® IPM™ 2031 offers rapid ink drying and a water-resistant material. It combines good adhesion during its life and easy removal afterwards.

Description

Facefilm: 80-micron premium white calendered, topcoated vinyl.

Adhesive: removable, acrylic based

Backing paper: one side coated kraft paper, 140 g/m²

Features

- Excellent printability
- Vibrant and bright colours
- Crisp print quality
- Spray water resistant with specific pigmented inks
- Good adhesion, excellent removability
- Warranty on outdoor durability

Recommendations for use

A wide variety of full-colour graphics for indoor - and **short/medium term outdoor** applications such as posters, murals, displays, exhibition stands, vehicle graphics etc. Avery® IPM™ 2031 is suitable for application to a wide variety of substrates and will remove cleanly for up to 1 year after application.

IPM media should be handled with care as any surface contamination may affect the print quality. Media should be processed in an environment of 15-25°C and 30-70% relative humidity. After drying, the finished prints should be wrapped in polyethylene film and despatched flat or rolled with the printed side facing outwards. To protect prints against water, UV/light and abrasion, overlamination with a clear film is recommended. For specific details of Avery® DOL combinations, refer to Technical Bulletin 5.3. Recommended combinations of Avery® Overlaminate and Avery® Digital Print Media.

Always test your combination of Avery® IPM™ medium, inkjet printer and inks prior to commercial use.

Compatibility

Avery® IPM™ 2031 is compatible with a broad selection of inkjet printers, when printing with pigmented, water based inks. For specific details refer to Technical Bulletin 5.6 Avery Dennison Inkjet Print Media - Printer compatibility.

Durability:

Avery® IPM™ 2031 is warranted for outdoor use in conjunction with pigmented outdoor inks from HP, Encad and Colorsprint. The warranted period varies from type of application and type of overlaminant from 18 months up to 5 years. For full details, see our Avery® IPM™ Outdoor warranty.



www.averygraphics.com

Graphics Division
Rijndijk 86, P.O. Box 118
2394 ZG Hazerswoude - The Netherlands
Tel +31 71 3421500 - Fax +31 71 3421538

PRODUCT CHARACTERISTICS

Avery® IPM™ 2031

Physical properties

Features	Test method ¹	Results
Caliper, facefilm	ISO 534	80 µm
Gloss	ISO 2813, 20°	1%
Dimensional stability	DIN 30646	0.3 mm. max
Adhesion, initial	FINAT FTM-1, stainless steel	180 N/m
Adhesion, ultimate	FINAT FTM-1, stainless steel	260 N/m
Flammability		Self extinguishing
Accelerating ageing	DIN 53587, 500h exposure	No negative impact on film
Shelf life	Stored at 22° C/50-55 % RH	Performance
Removability		2 years
Not when applied to: Nitro-cellulose paints, ABS, Polystyrene, certain types of PVC		up to 1 year
Durability ²	Overlaminated with DOL 4300 Overlaminated with DOL 1000, DOL 1100 with overlaps Overlaminated without overlaps for static applications only Without overlaminates and used for static, Non-abrasive application ONLY	5 years 3 years 2 years 18 months

Only when printed with ENCAD GO, HP and Colorsprint pigmented inks and when properly applied in accordance with our application instructions. Only applicable for vertical exposure.

Temperature range

Features	Results
Application temperature	Minimum: +10°C
Service temperature	-20°C to +80°C

Important

Information on physical and chemical characteristics is based upon tests we believe to be reliable. The values listed herein are typical values and are not for use in specifications. They are intended only as a source of information and are given without guarantee and do not constitute a warranty. Purchasers should independently determine, prior to use, the suitability of this material to their specific use.

All technical data are subject to change. In case of any ambiguities or differences between the English and foreign versions of these Conditions, the English version shall be controlling.

Warranty

Avery® branded materials are manufactured under careful quality control and are warranted to be free from defect in material and workmanship. Any material shown to our satisfaction to be defective at the time of sale will be replaced without charge. Our aggregate liability to the purchaser shall in no circumstances exceed the cost of the defective materials supplied. No salesman, representative or agent is authorised to give any guarantee, warranty, or make any representation contrary to the foregoing.

All Avery® branded materials are sold subject to the above conditions, being part of our standard conditions of sale, a copy of which is available on request.

1) Test methods

More information about our test methods can be found on our website.

2) Durability

The durability is based on middle European exposure conditions. Actual performance life will depend on substrate preparation, exposure conditions and maintenance of the marking. For instance, in the case of signs facing south; in areas of long high temperature exposure such as southern European countries; in industrially polluted areas or high altitudes, exterior performance will be decreased.



www.averygraphics.com

Graphics Division
Rijndijk 86, P.O. Box 118
2394 ZG Hazerswoude - The Netherlands
Tel +31 71 3421500 - Fax +31 71 3421538